



Dart Aerospace Ltd.
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K6A 1K7
Canada

Tel (613) 632-5200

D4854-3
Job Sheet 172027



Part No: D4854-3

Job Qty: 12 ea

Part Name: Lower Bracket



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/12/18

Job Tracking No:

Due Date: 2/23/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: D4854 REV.B IPP REV:A NEW ISSUE 13-07-22 JLM VERIFIED BY:JFS IPP REV:B 17.12.07 AS PER DWG
REV.B DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea		2/22/18	0.00	0.00	Start Up Waterjet		SC 18/02/14
100	Waterjet	12 pcs		2/22/18	0.00	3.00	Waterjet1		SC 18/02/14
105	QC	12 pcs		2/22/18	0.00	0.00	QC2 Waterjet-1		SC 18/02/14
110	Mill Conv	12 pcs		2/22/18	0.00	10.53	Mill Conv 1		SC 18/02/14
120	QC	12 pcs		2/22/18	0.00	0.00	QC2 Machining-3		SC 18/02/14
130	QC	12 pcs		2/22/18	0.00	0.00	QC8 Machining-3		SC 18/02/14
140	HandFinish	12 pcs		2/22/18	0.00	0.10	HandFinish1		SA 18-3-28
150	QC	12 pcs		2/22/18	0.00	0.00	QC7-4		BR 18-3-29
160	Powdercoat	12 pcs		2/23/18	0.00	0.60	Powdercoat1		
170	QC	12 pcs		2/23/18	0.00	0.00	QC3		DAS 11 APR 03 2018
180	Packaging	12 pcs		2/23/18	0.00	0.00	Packaging3-2		9-89 APR 04 2018
190	QC21-SA	12 Ea		2/23/18	0.00	0.00	QC21		DAS 9-89 APR 05 2018

Part Op 100 - CUT AS PER FILE DWG REV: B PROG REV: B DEBURR
Descriptions: 110 - MILL RADS DRILL HOLES AS PER DWG DEBURR OPEN SLOT TO .260" AS PER DWG
160 - ***MASK AS PER DWG*** START TIME: 10.35 OVEN TEMPERATURE: 220° FINISH TIME:
11.25 M138760

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.750X04.000	6061-T6 Bar .750 X 4.00	4.9872 ft (4156 ea)	90-Start up Operation	
	<u>M127510-142</u>	<u>(11)</u>		

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B0.750X04.000	5	7	0

Part Specifications

Specifications could not be found.



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CANADA
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Container No: S044451



Part: D4854-3

Job No: 172027

Serial No/Batch: S044451

Revision: D4854
Inspector:

Date: 02/22/18

11
11
11

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					